

Work Order ID 117861

May-05-14 11:46:19 AM

117861

Page 1

Item ID: D205-626-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Handle™ LH

Start Date: 5/12/14 Start Qty: 2.00

***P*3**
Q

Cust Item ID:

Required Date: 5/12/14 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 14-05-06 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D205-626	Rev B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP	D205-626-011							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

CHG 002

ML5 15-10-14

DAS
38
9-89

15-10-15

3X

DAS
27
9-89

DAS
02
9-89

OCT 14 2015

3

DAS
38
9-89

15-10-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 117861

117861

Page 2

May-05-14 11:46:19 AM

Item ID: D205-626-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Handle™ LH

Start Date: 5/12/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/12/14 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							DAS
Packaging	Identify and pack for shipping as per PPP D205-626-011								6
	Location: <u>017</u>								9-89
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

3 OCT 15 2014

MCS OCT 15 2015

MCS OCT 15 2015

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Doc/Data									
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

May-05-14 11:46:18 AM

Page 1

Work Order ID: 117861

117861

Parent Item: D205-626-011

D205-626-011

Parent Item Name: Heli-Access-Handle™ LH

Start Date: 5/12/14

Required Date: 5/12/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B Reformat 00-03-03 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2480-011		Manufactured	No			110	Each	0.0000	1	3			
D2480-011								B137459		3			
Handle Weldment LH													DAS 02 9-89
AN526C632R7		Purchased	No			110	Each	104.0000	6	18			
AN526C632R7									**				
Screw												DAS 27 9-89	DAS 02 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST345		104							
					112385	43		M129339		18			
					117317	61							
NAS1149DN632J		Purchased	No			110	Each	687.0000	6	18			
NAS1149DN632J									**				
Washer												DAS 27 9-89	DAS 02 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST293		687							
					M126084	11		M12677		18			
					M127255	100							
					M128606	176							
					M128812	400							

OCT 14 2015

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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 2

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Work Order ID: 117861

117861

Parent Item: D205-626-011

D205-626-011

Parent Item Name: Heli-Access-Handle™ LH

Start Date: 5/12/14

Required Date: 5/12/14

Start Qty: 2.00

Required Qty: 2.00

MS21042L06

Purchased

No

110

Each

678.0000

6

18

MS21042L 06

Nut

DAS
38
9-89

**

BAS

27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST314

678

m127304

20

m127831

58

m128401

200

m128754

200

m128976

200

m132803

18

OCT 14 2015

DQA: _____ Date: _____



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4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-626 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-626-011	1.3 lb	-46.5 in	-60.5 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, LH	0.59 kg	-1.18 m	-0.70 m-kg	2.21 m	1.31 m-kg
D205-626-012	1.3 lb	46.5 in	60.5 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, RH	0.59 kg	1.18 m	0.70 m-kg	2.21 m	1.31 m-kg
D205-626-013	1.3 lb	-50.5 in	-65.7 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, LH (Spacedoor™)	0.59 kg	-1.28 m	-0.76 m-kg	2.21 m	1.31 m-kg
D205-626-014	1.3 lb	50.5 in	65.7 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, RH (Spacedoor™)	0.59 kg	1.28 m	0.76 m-kg	2.21 m	1.31 m-kg

5. PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D205-626-011	HELI-ACCESS-HANDLE™, LH (STANDARD)
	X			D205-626-012	HELI-ACCESS-HANDLE™, RH (STANDARD)
		X		D205-626-013	HELI-ACCESS-HANDLE™, LH (SPACEDOOR™)
			X	D205-626-014	HELI-ACCESS-HANDLE™, RH (SPACEDOOR™)
1		1		D2480-011	HANDLE ASSEMBLY, LH
	1		1	D2480-012	HANDLE ASSEMBLY, RH
		2	2	D2481	DOUBLER
		2	2	80-005-1-8	INSERT
6	6			AN526C632R7	SCREW
6	6			MS21042L06	NUT
		4	4	MS21042L08	NUT
		2	2	MS27039-0805	SCREW
		4	4	MS27039-0809	SCREW
6	6			NAS1149DN632J	WASHER (OR AN960JD6)
		10	10	NAS1149FN816P	WASHER (OR AN960-8L)